

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-026416**Date Inspected:** 27-Sep-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1100**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Watson Bowman ACME**Location:** Buffalo, NY**CWI Name:** Reno Davis**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date, Quality Assurance Inspector (QAI) Kenneth Riley was present at the Watson Bowman Acme Corporation (WBA) facility, as requested, in Buffalo, New York to observe fabrication activities of the Seismic Expansion Joint Hinge A lanes for the San Francisco Oakland Bay Bridge (SFOBB) project.

This (QA) Inspector met with Watson Bowman Acme Corporation (WBA) Quality Control (QC) Supervisor John Miller and KTA-Tator (ABF Representative), Certified Welding Inspectors (CWI), Reno Davis.

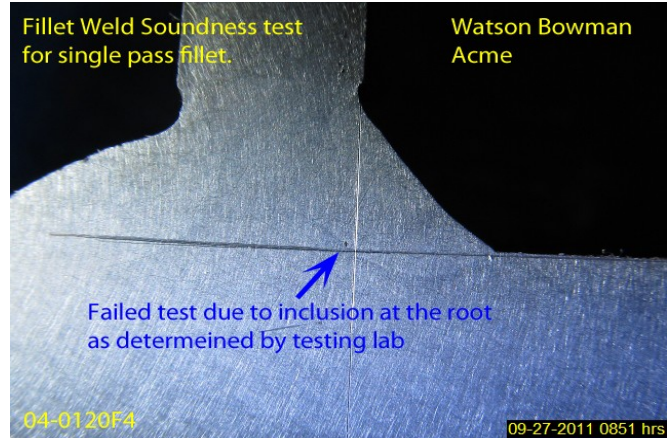
This QAI observed WBA welding personnel Gary Janus and Jayson Gray performing welding, grinding and clean up on (4) four channel box assemblies identified as SEI112667 CA2-1,4,6, and 8. Mr. Janus was observed as removing weld spatter grinding weld termination and a general overall cleaning of the assemblies. Mr. Gray was observed as performing weld repairs that were identified by WBA QC John Miller. These are included undercut and start/stop locations behind the stiffeners at the snipe locations. Mr. Gray was observed using a rose bud torch to pre-heat the areas to 107 degrees Celsius (225F). The process used for the welding was Flux Core Arc Welding (FCAW) with Hobart (Tri-Mark) TM-811N1 electrode. The parameters appeared to be within the specified Welding Procedure Specification (WPS) WBA-FCAW-CA-2010. WBA night shift welding personnel James DiVirgillio arrived at WBA to perform welding on the seismic Expansion Joint Hinge A assemblies. This QAI met with Mr. DiVirgillio as he was directed with the welding that was to be performed this night by Mr. Miller. Mr. Miller stated that WBA would remove every other stiffener and place the Complete Joint Penetration (CJP) weld and the reinforcing fillet weld at these locations to have continuous welding behind the snipes. Mr. Miller and Mr. Davis will be monitoring the welding process on the night shift.

This QAI was also given results of the single pass fillet weld soundness test. The testing was performed by

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Niagara Testing in Buffalo, NY and witnessed by ABF representative Reno Davis. The results were as follows; Visual Acceptable, Macro #1 Failure, Macro #2 Failure, and Macro #3 Acceptable. This QAI Spoke with WBA QC John Miller concerning these results and what direction WBA would be taking to secure a successful soundness test, it was stated that WBA would produce another Soundness test tomorrow afternoon and submit it to the same lab for testing and he would be there to witness the testing himself also.



Summary of Conversations:

Basic conversation, fundamental to completion of the tasks at hand, occurred between this QAI, ABF QC, and WBA personnel .

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy 510-385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Riley, Ken	Quality Assurance Inspector
Reviewed By:	Levell, Bill	QA Reviewer
